

Ship Friday

Work Order ID 50229

July 10, 2009 1:19:05 PM



Item ID: D3935-2
Revision ID: A
Item Name: Pylon Protector

Accept



Setup Start
Stop



Start Date: 07/13/2009 Start Qty: 8.00
Required Date: 07/16/2009 Req'd Qty: 8.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
----------	--------------

100

Waterjet
FLOW CNC Waterjet

Memo
1-Cut as per Dwg D3935
Dwg Rev: A
Prog Rev: A
2- Deburr if necessary

0.00
0.00
⇒ ml 09 07 14 (89)

110

QC
Quality Control

QC2- Inspect parts off machine FAI/FAIB
Memo

0.00
0.00
⇒ ml 09 07 14 (89)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

=> 8 09/07/14 (92) 0

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

(SHIP 1 pc done to site 4) 9/7/14 (92) SF

140

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

09/07/15

MF 09-07-75

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Picklist Print

July 10, 2009 1:19:04 PM

Work Order ID: 50229

Parent Item: D3935-2RevA

Parent Item Name: Pylon Protector

Comments:

Start Date: 07/13/2009

Required Date: 07/16/2009

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	1,278.050	69.5200			



GE PLASTICS LEXAN SHEET

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	1278.05	
103106	7.8	
105330	54	
109455	0.03	
111710	1216.22	

m.m 09.07.14

Dart Aerospace Ltd

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DART AEROSPACE LTD		Work Order:	50229
Description: Pylon Wall Protector, RH		Part Number:	D3935-2
Inspection Dwg: D3935 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.50	✓		M.T	
9.00	+/-0.030	9.00	✓		M.T	
14.70	+/-0.030	14.70	✓		M.T	
16.20	+/-0.030	16.20	✓		M.T	
33.40	+/-0.030	33.40	✓		M.T	
34.25	+/-0.030	34.25	✓		M.T	
34.60	+/-0.030	34.60	✓		M.T	
34.72	+/-0.030	34.72	✓		M.T	
22.85	+/-0.030	22.85	✓		M.T	
19.15	+/-0.030	19.15	✓		M.T	
35.39	+/-0.030	35.39	✓		M.T	
8.05	+/-0.030	8.05	✓		M.T	
15.05	+/-0.030	15.05	✓		M.T	
19.00	+/-0.030	19.00	✓		M.T	
19.25	+/-0.030	19.25	✓		M.T	
20.25	+/-0.030	20.25	✓		M.T	
23.25	+/-0.030	23.25	✓		M.T	
24.35	+/-0.030	24.35	✓		M.T	
29.25	+/-0.030	29.25	✓		M.T	
32.75	+/-0.030	32.75	✓		M.T	
0125	+/-0.010	0.127	✓		Wen	

Measured by:	M. M	Audited by:	S	Prototype Approval:	N/A
Date:	09.07.14	Date:	09.07.14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.06.22	New Issue	KJ	

Dart Aerospace Ltd

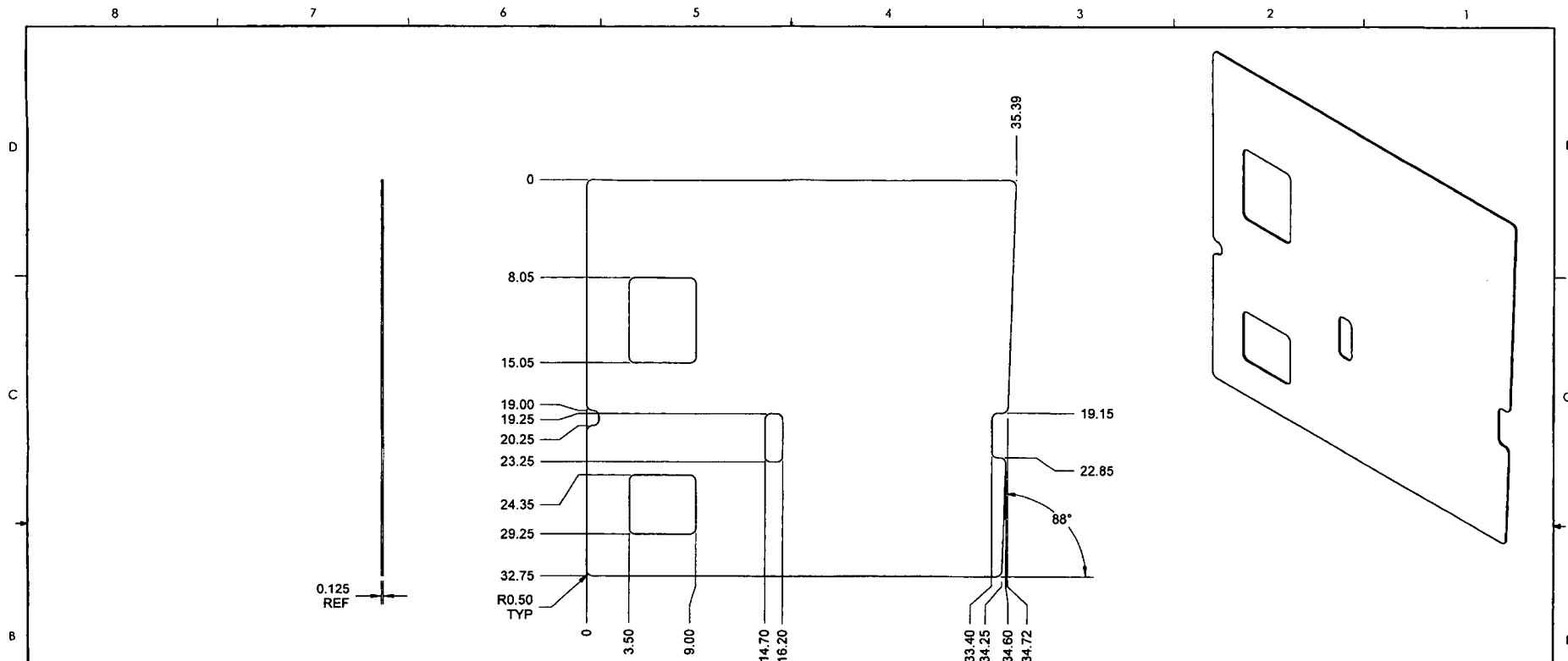
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D3935-2 PYLON WALL PROTECTOR, RH
(TEXTURED SIDE SHOWN)

RELEASED
09/06/05 JH

NOTES:

- 1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3935-2" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 5.79 lbs
- 8) CHECK PER TEMPLATE DT8923

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 50 039
MF 09-07-10

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3935	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PYLON PROTECTOR	NTS
DATE	09.04.21	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
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